

Date: Thursday, 6/5/2008 1:05:15 PM
 User: David Duvall

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 05030		Part Number	: D35891	
Estimate Number	: 13350		Drawing Number	: D3589 PROTO 08-06-05	
P.O. Number	:		Project Number	: VR0004	
This Issue	: 6/5/2008	S.O. No. :	Drawing Revision	: PROTO	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : R & D SM/MED FAB	Due Date	: 6/12/2008	Qty: 2 Um: Each
Previous Run	:				
Written By	: <u>AD 08/06/05</u>				
Checked & Approved By	:				
Comment	: Est Rev:A 08-05-29 new issue DD verified by:EC				

Additional Product

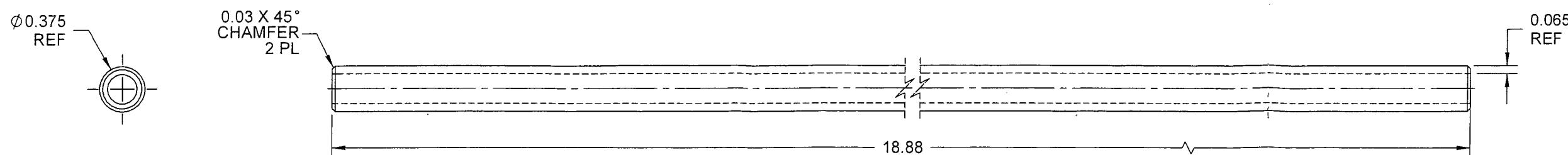
PROTOTYPE

Job Number:		FOR ENGINEERING USE ONLY
Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0375W065	304 RD Tube .375 x .065W
		
Comment:	Qty.: 1.6520 f(s)/Unit Total : 3.3039 f(s)	
	304 RD Tube .375 x .065W	FF 08-06-05
	batch: <u>M18993</u>	(2)
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment:	SMALL & MEDIUM FAB RESOURCE 1	
	1-cut D3589-1 as per dwg D3589	FF 08-06-05
	2-deburr both ends as per dwg D3589	(2)
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment:	INSPECT WORK TO CURRENT STEP	08-06-09
	ENGINEERING APPROVAL	(2)
4.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment:	PACKAGING RESOURCE #1	18-06-06 (2)
	Identify and Stock:	
	Location:	
5.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment:	FINAL INSPECTION/W/O RELEASE	18-06-09 Prototype
Job Completion		charge to w/o # 00224 MF 08-06-13

8 7 6 5 4 3 2 1

D

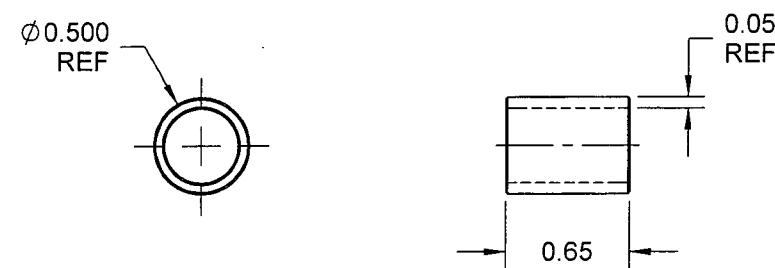
D



D3589-1 ARM

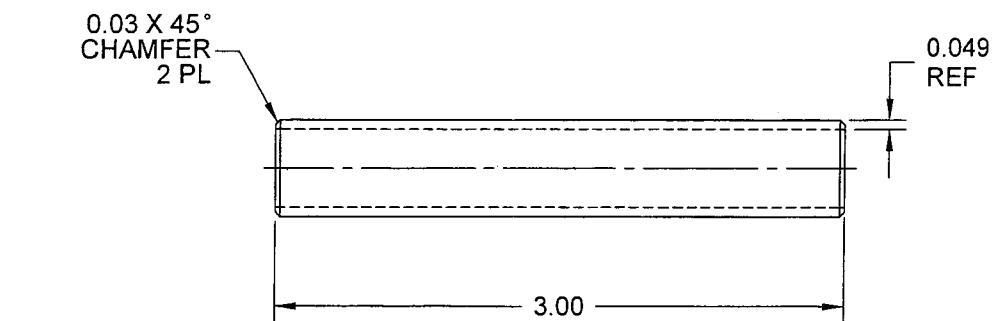
C

C



D3589-3 ARM GUIDE

QTY 8



D3589-5 LATCH GUIDE

B

B

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
18.06.05

D3589-1/3/5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 - D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 - D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 - D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO.
MFG. APPR.	1	D3589
APPROVED	1	REV. A
DE APPR.	1	SHEET 4 OF 8
		SCALE
		NTS
		TITLE
		LATCH ASSEMBLY
DATE	08.05.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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8 7 6 5 4 3 2 1

A

Date: Thursday, 6/5/2008 1:05:15 PM
User: David Buvat

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 05030		Part Number	: D35891		
Estimate Number	: 13350		Drawing Number	: D3589 PROTO		
P.O. Number	:		Project Number	: VR0004		
This Issue	: 6/5/2008	S.O. No. :	Drawing Revision	: PROTO		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : R & D SM/MED FAB	Due Date	: 6/12/2008 Qty: 2 Um: Each		
Previous Run	:					
Written By	: <u>David Buvat</u>					
Checked & Approved By						
Comment	: Est Rev:A 08-05-29 new issue DD verified by:EC					

Additional Product

PROTOTYPE

Job Number:		FOR ENGINEERING USE ONLY
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Seq. #:	Machine Or Operation:	Description:
1.0	M304TR0375W065 	304 RD Tube .375 x .065W <i>McCurdy P/O: 2008892</i> 

Comment: Qty.: 1.6520 f(s)/Unit Total : 3.3039 f(s)	304 RD Tube .375 x .065W	batch: <u>M18993</u>	FF 08-06-05
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2.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1	
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Comment: SMALL & MEDIUM FAB RESOURCE 1	1- cut D3589-1 as per dwg D3589	2- deburr both ends as per dwg D3589	FF 08-06-05
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3.0	QC5 	INSPECT WORK TO CURRENT STEP	
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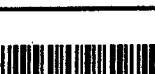
**ENGINEERING
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP	FOR ENGINEERING USE ONLY
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4.0	PACKAGING 1 	PACKAGING RESOURCE #1	
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FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1	Identify and Stock	Location:	FF 08-06-05
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5.0	QC21 	FINAL INSPECTION/W/O RELEASE	
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Comment: FINAL INSPECTION/W/O RELEASE	charge to w/p # 00224
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Job Completion	
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Receiving Report

Date: 05/11/07

Supplier: MARMAN/Keystone

Batch No: 18993

Dart P/O: 2008892

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr.

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No
 Q.C. Inspection BL OK

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

TSR No.

Initials of receiver (if shipment OK) DCZ

Production/Admin:

Date 05/11/07

Received/Costing KCL03

Initial AP

H:\ISO9000\Forms\Purchase\RECREPORT rev B

Accounting:

Date

AP/MR

Initial

